

Work Order ID 59198

Friday, May 28, 2010 9:16:51 AM



Page 1

Item ID: D2744

Accept



Setup Start

Revision ID:

Stop

Item Name: Cap



Start Date: 5/27/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2744

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2744 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-

3052 1.000

Deburr if necessary

IB 10-6-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-6-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/6/03

counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *LG*

0.00

Packaging

Memo

0.00

Packaging

*10-6-4**36x SP*

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*10/06/07**ME**10-6-7*

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Picklist Print

Friday, May 28, 2010 9:16:55 AM

Page 1

Work Order ID: 59198

Parent Item: D2744

Parent Item Name: Cap


Comments: IPP ☐ C ☐ 03.01.17 ☐ Reformat; Dwg revised ☐ KJ/RF
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP Rev:E As per Rev C 07-07-28 JLM Verified By: ☐

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M5052H32S.080		Purchased	No			100	sf	102.9342	0.1823	3.837895	6.6		
													
5052-H32 .080 Sheet													

Location

MAT22

Loc Qty

102.9342

Loc Code

100682

5

100742

62

100947

32.9342

19729

3

100742

36

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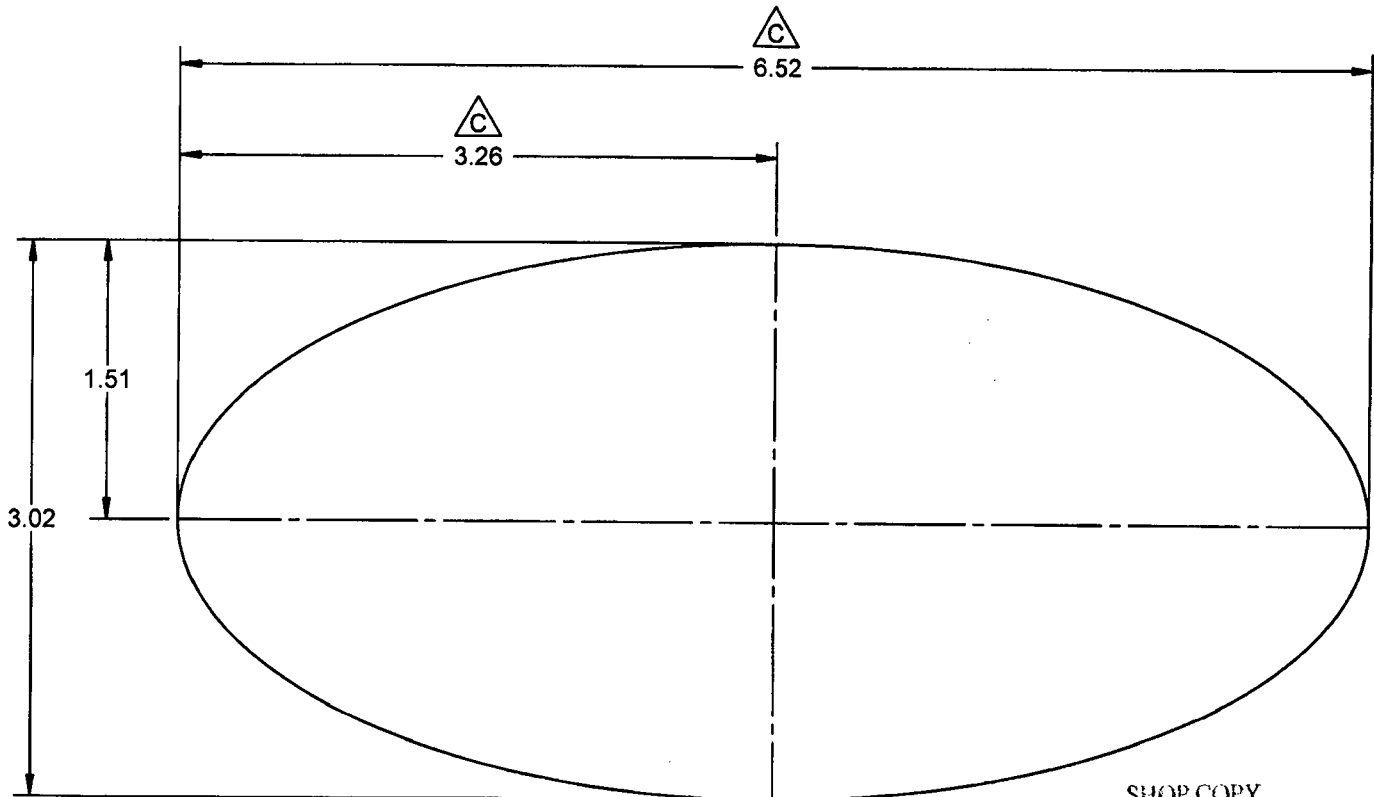
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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED #	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08-02 #**D2744 CAP**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59198
BJ 10-5-28

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

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